

Work Order ID 157232

Tuesday, February 21, 2017 7:59:23 AM

157232

Page 1

Item ID: D2322

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Spacer

Start Date: 2/13/2017 Start Qty: 10.00

10

Cust Item ID:

Required Date: 2/17/2017 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: FEB 22 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2322

Rev C

100

0.03

100

FLOW WATER JET

Waterjet

Memo

0.08

FLOW CNC Waterjet

1-Cut as per Dwg D2322 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

(14)

02/17/02/27

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.02

Quality Control

(14)

02/17/02/27

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.03

Quality Control

14

FEB 28 2017

DAS
38
9-89

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Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D2322

0.04

0.03

DAS
30
9-89

MAR 03 2017

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.03

DAS
38
9-89

MAR 03 2017

150

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.05

2017/03/08
BEB

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Page 3

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Start Date: 2/13/2017 Start Qty: 10.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.02

Quality Control

14

DAS
38
9-89

MAR 09 2017

170

Identify as per dwg & Stock Location

0.00

170

Packaging

Memo

0.02

Packaging

LOCATION : GA

14X

MAR 10 2017

DAS
26
9-89

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.17

Quality Control

17/3/13

A

MAR 10 2017

Picklist Print

Tuesday, February 21, 2017 7:58:49 AM

Page 1

Work Order ID: 157232

157232

Parent Item: D2322

D2322

Parent Item Name: Step Spacer

Start Date: 2/13/2017

Required Date: 2/17/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 05-11-07 JLM
IPP Rev;B Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased			No	100	sf	63.4900	0.203	2.136842			

M2024T3S 040

2024-T3 .040 sheet

**

02/17/02/27

Location

Loc Qty

Loc Code

MAT022

63.49

m135032

2

m136200

13.49

m136770

48

3.1



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
BW	CP	DRAWING NO.	D2322	REV. C
CHECKED	APPROVED	DATE	98.09.29	SHEET 1 OF 1
KE	[Signature]	TITLE	STEP SPACER	SCALE
				1:2
A	94.10.14	NEW ISSUE		
C	98.09.29	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER NCR 001		

RELEASED
18.10.08 DS

UNDER REVIEW

01.03.15 CP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 157232 MCT

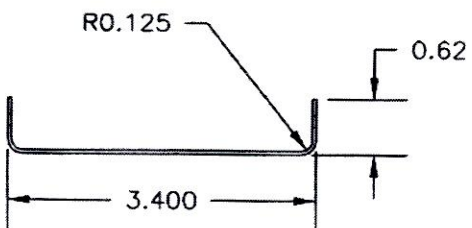
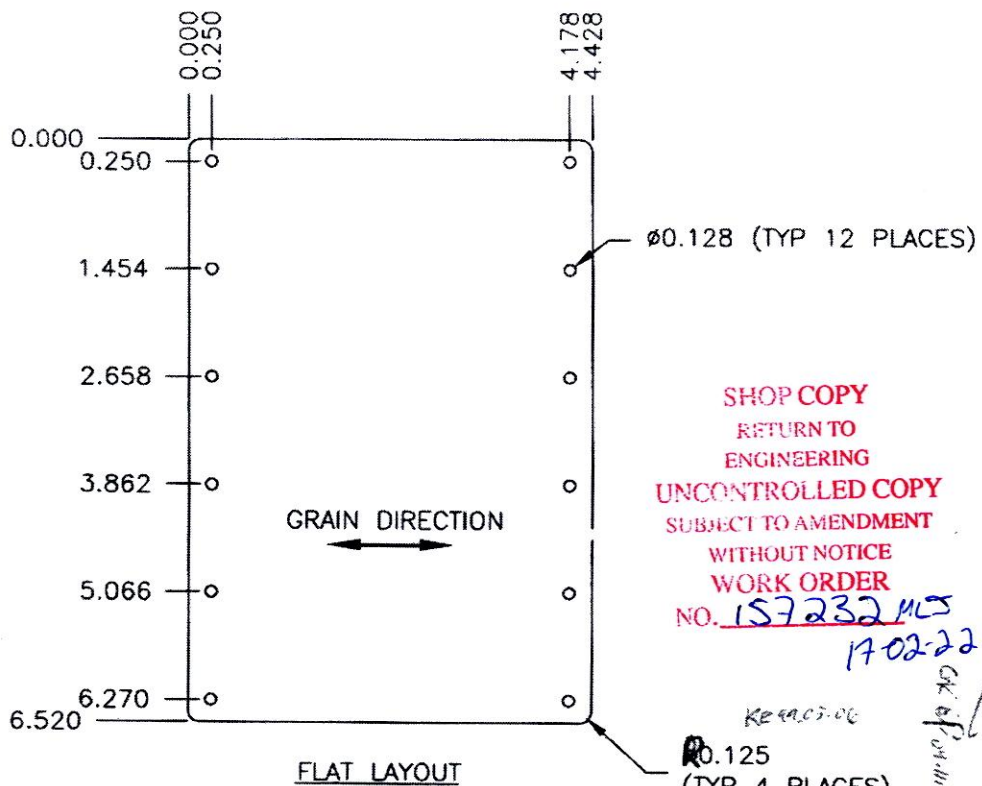
17-02-22

DESIGN OK, BUT CHECK WITH
JTS BEFORE MANUFACTURE

OK 6/10/09

KE 01.03.06

R0.125
(TYP 4 PLACES)



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED